



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

650.7310

Job Sheet 210908

AE 138
VAWE ASSY



Part No: 650.7310

Job Qty: 5 pcs

Part Name: Spring Stop



Part Weight: 0 lbs

Job Created: 6/26/20

Due Date: 7/15/20

Type: SOLD

Note: 650.7300 REV.A IPP REV:A 20.06.24 NEW ISSUE DD VERF:JFS

Ship Via:

PRELIMINARY ISSUE

Status: New

Priority: Medium

Job Tracking No:

Created By: Marie Lajeunesse

Description:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	SL-154 - 1	5 pcs	7/15/20		1.00	1.25	Doosan - 1		
							NLX 2500SY - 1		
							SL-154 - 1		
							SL-2500Y - 1		JL 20.7-7
110	QC 2	5 pcs	7/15/20		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		JL
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		

DART AEROSPACE
Part: 650.7310
Job No: 210908
Serial No/Batch: S286595
Revision: REV.A
Inspector:
Exp Date:
Instructions:
Date: 07/07/20

Container No: S286595
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
Tel.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Plex 6/26/20 7:04 AM Dart.lajeunesse.marie

120	QC 8	5 pcs	7/15/20	0.00 0.00	QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 2 - 76	
					QC 2 - 86	
					QC 2 - 83	
					QC 8 - 12	
					QC 8 - 14	P/L 20/07/09
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
160	Packaging 3-1 - Stock - B4B	5 pcs	7/15/20	0.00 0.00	QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
					QC 8 - 61	
					QC 8 - 66	
					QC 8 - 73	
					QC 8 - 82	
					Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	

				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	PC GA+BD
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 37 - B4B	
170 QC 21 - SA	5 pcs	7/15/20	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 9	

Part Op 100 - ***CRITICAL PART - EXTREME CARE MUST BE TAKEN*** 1-Machine as per folio F FOLIO REV: _____

Descriptions: DWG REV: _____ 2-Debur

110 - QC2- Inspect parts off machine FAI/FAIB

120 - QC8- Inspect parts - second check

160 - Identify as per dwg & Stock ***CRITICAL PART - EXTREME CARE MUST BE TAKEN*** MUST ENSURE THE COMPONENTS ARE NEVER DAMAGE****

170 - QC21- Final Inspection - Work Order Release

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M303R0.750	303 Round Bar 0.750	.2000 ft (.04 ea)	100-SL-154 - 1	2281599-43

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-SL-154 - 1	M303R0.750	0	32	0

Part Specifications	
Specifications could not be found.	

Plex 6/26/20 7:04 AM Dart.lajeunesse.marie

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only



Job: _____ Part No. _____	DISPOSITION Rework ☐ ☐ ☐ Scrap ☐ ☐ ☐ Use-as-is ☐ ☐ ☐	DEPARTMENT/PROCESS Cross tube ☐ ☐ ☐ Small Fab ☐ ☐ ☐ Finishing ☐ ☐ ☐ Skid-tube ☐ ☐ ☐ Machining ☐ ☐ ☐ Large Fab ☐ ☐ ☐ Eng. (Non-AW) ☐ ☐ ☐ Prod. Eng. Coord. ☐ ☐ ☐ Rec/Store/Packaging ☐ ☐ ☐ Engineering ☐ ☐ ☐ Water Jet ☐ ☐ ☐ Supplier ☐ ☐ ☐ Quality ☐ ☐ ☐	MRB (QS1042)
Date : _____		Sequence #: _____	
Description Work Order Deviation		Disposition	
		Completed By	
Root Cause Operator ☐ ☐ ☐ Manufacturing Process ☐ ☐ ☐ Equip/Tooling ☐ ☐ ☐ Handling/Preservation ☐ ☐ ☐ Material ☐ ☐ ☐ Product Improvement ☐ ☐ ☐ Process Improvement ☐ ☐ ☐ Human Factors ☐ ☐ ☐		FAULT CATEGORY Pressure/Forced ☐ ☐ ☐ Bending ☐ ☐ ☐ Crushing ☐ ☐ ☐ Cracks ☐ ☐ ☐ Crimp/Kink/Ripple/Wave/Twist ☐ ☐ ☐ Marks/Chatter ☐ ☐ ☐ Mislabeled ☐ ☐ ☐ Other/Details: _____	
		Contamination ☐ ☐ ☐ Misaligned/off center ☐ ☐ ☐ BOM/Route ☐ ☐ ☐ Broken/Damage/Defect ☐ ☐ ☐ Incomplete/Unclear Instructions ☐ ☐ ☐ Drill Holes ☐ ☐ ☐ Fit/Function ☐ ☐ ☐	
		Power Loss/Surge ☐ ☐ ☐ Folio/Program ☐ ☐ ☐ Grain Direction ☐ ☐ ☐ Weld ☐ ☐ ☐ Wrong Stock Pulled ☐ ☐ ☐ Out of Sequence ☐ ☐ ☐ Off-set/Set-up ☐ ☐ ☐	
		Positioned Wrong ☐ ☐ ☐ Outside Tolerance ☐ ☐ ☐ Drawing ☐ ☐ ☐ Finish ☐ ☐ ☐ Part Lost/Missing ☐ ☐ ☐ Misread ☐ ☐ ☐	
		QC / QA Coordinator	
		Lead hand / Supervisor	

DART AEROSPACE LTD		Work Order:	210908
Description: spring stop		Part Number:	650.7310
Inspection Dwg: 650.7300		Rev: A	Page 1 of 1

INSPECTION SHEET

	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
①	365	±.005	366	/		VERU	SL-2
②	.080	±.005	.080	/		"	"
③	R.020	±.005	R.020	/		R-G	(ref)
④	R.005	±.005	R.005	/		"	"
⑤	R.015	±.005	R.015	/		"	"
⑥	R.005	±.005	R.005	/		"	"
⑦	R.015	±.005	R.015	/		"	"
⑧	R.010	±.005	R.010	/		"	"
⑨	.255	+-.003 -0	.2555	/		G-PIN	
⑩	.180	±.005	.181	/		VERU	SL-2
⑪	.395	±.005	.395	/		"	"
⑫	Ø.070	±.005	Ø.072	/		"	"
⑬	T.065	±.005	.065	/		G-PIN+VERU	SL-2
⑭	.530	±.005	.530	/		VERU	SL-2
⑮	120°	±.5°	120°	/			
⑯	.603	±.005	.605	/		VERU	SL-2
⑰	.313	±.005	.315	/		"	"
⑱	.615	±.005	.616	/		"	"
⑲	665-32mm-3A						
	major Ø .662	±.003	.662	/		mic	SL-04
	min Ø .6703	±.005	.6703	/		"	"
	#wires .018*						

Measured by: JL	Checked by: [Signature]	QC Inspector:
Date: 20-7-7	Date: 20/07/09	Date:

Engineering Approval: (If necessary)	Date:
--	--------------

Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	